

Work Order ID 145946

145946

Page 1

Friday, May 06, 2016 8:55:40 AM

Item ID: D350-689-023 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Floor Provisions Energy Attenuating Seat Compatible
 Start Date: 5/2/2016 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 5/10/2016 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: dm Date: 16/05/06 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D350-689	C								
100	Document Control	0.00							
100	DOCUMENT CONTROL	MAY 12 2016							
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D350-689-023 CHG004								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.06							
Quality Control									

MC5 1605-12

2 DAS 28 9-89
 MAY 04 2016

2

DAS 27 9-89

MAY 12 2016

2 DAS 28 9-89

JUL 04 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____						
Misidentified	☐	Past Due	☐							

Work Order ID 145946

Friday, May 06, 2016 8:55:40 AM

145946

Page 2

Item ID: D350-689-023

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Floor Provisions Energy Attenuating Seat Compatible

Start Date: 5/2/2016 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 5/10/2016 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00				<u>2</u>	<u>DAS</u> <u>28</u> <u>9-89</u>	<u>DAS</u> <u>27</u> <u>9-89</u>	<u>JUL 04 2016</u>
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-689-023								
	Location: FG027								
140	QC21- Final Inspection - Work Order Release	0.00							
140							<u>DAS</u> <u>21</u> <u>9-89</u>	<u>JUL 05 2016</u>	
QC	Memo	0.20							
Quality Control									

DAS
21
9-89 JUL 05 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐			

Picklist Print

Friday, May 06, 2016 8:55:39 AM

Page 1/2

Work Order ID: 145946

145946

Parent Item: D350-689-023

D350-689-023

Parent Item Name: Floor Provisions Energy Attenuating Seat Compatible

Start Date: 5/2/2016

Required Date: 5/10/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-23 new issue DD verified by:EC IPP Rev:B
revise route seq DD 10.02.12 vrified byJLM IPP Rev:C chg003 DD
11.09.28 verified by:JLM IPP Rev:D 12.01.12 now @
CHG004 (ecn12-501) DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status DAS
D4575-1		Manufactured	No			110	Each	3.0000	1	2			DAS 6 9-89
D4575-1									**				DAS 27 9-89
Beam													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST259			3					
					143483			3		2			
D4575-3		Manufactured	No			110	Each	4.0000	1	2			DAS 6 9-89
D4575-3									**				DAS 27 9-89
Doubler													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST259			4		2			
					143403			4					
D3027-7		Manufactured	No			110	Each	1.0000	4	8			DAS 27 9-89
D3027-7									**				DAS 6 9-89
Clip													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST015			1		1			
					139559			1					
D3811-041		Manufactured	No			110	Each	4.0000	1	2			DAS 27 9-89
D3811-041									**				DAS 6 9-89
Seat Track Assembly													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST259			4		2			
					140025			4					

MAY 13 2016

B.147054

MAY 13 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY					
Environment ☐	☐	No Re-verification	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	☐	Operator	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	☐	Offset/Setup	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	☐	Supplier	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	☐	Training	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	☐	Use for Testing	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	☐	Poor Information	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	☐	Rushing	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	☐	Product Improvement	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	☐	Process Improvement	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	☐	Manufacturing Process	OTHER : _____					
Misidentified ☐	☐	Past Due						

Picklist Print

Page 2

Friday, May 06, 2016 8:55:39 AM

Work Order ID: 145946

145946

Parent Item: D350-689-023

D350-689-023

Parent Item Name: Floor Provisions Energy Attenuating Seat Compatible

Start Date: 5/2/2016

Required Date: 5/10/2016

Start Qty: 2.00

Required Qty: 2.00

MS21042L3 Purchased No 110 Each 1,726.000 9 18

MS21042L3

Nut

DAS 6 27
9-89 9-89

DAS
28
9-89

Location	Loc Qty	Loc Code
FP001	100	
m133790	100	
GA	701	
m133790	3	
m134360	698	
ST303	925	
m134039	12	
m134360	313	
m134634	600	

MS24694-S50 Purchased No 110 Each 447.0000 9 18

MS24694-S50

Screw

DAS 6 27
9-89 9-89

DAS
28
9-89

Location	Loc Qty	Loc Code
GA	129	
m134370	129	
ST284	318	
m134502	318	

NAS1149D0363J Purchased No 110 Each 2,248.000 9 18

NAS1149D0363J

Washer

DAS 6 27
9-89 9-89

DAS
28
9-89

Location	Loc Qty	Loc Code
GA	518	
m134055	518	
ST260a	1000	
m134676	1000	
ST263	730	
m134606	730	

Friday, May 06, 2016 8:55:39 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER :									

5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -041	Qty -043	Part Number	Description
X						D350-689-011	DUAL HIGH BACK SEAT INSTALLATION, LH
1	X					D350-689-013	FLOOR PROVISIONS KIT
		X				D350-689-021	DUAL HIGH BACK SEAT INSTALLATION, LH
		1	X			D350-689-023	ENERGY ATTENUATING FLOOR PROVISIONS KIT
1				X		D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
		1			X	D350-689-043	DUAL HIGH BACK SEAT ASSEMBLY
1		1				D3018-1	SEAT CUSHION
1		1				D3019-1	BACK CUSHION
	1					D3025-1	BEAM
	1					D3027-1	CLIP
	1					D3027-3	CLIP
	1					D3027-5	CLIP
	4		4			D3027-7	CLIP
				4		D3028-1	STUD
				2		D3029-1	SPRING
				2		D3030-1	LOCK
	1					D3032-1	SPACER
	2					D3033-1	SEAT TRACK
	1					D3234-1	DOUBLER
	2					D3234-5	SPACER
					2	D3808-041	SEAT RAIL ASSEMBLY
					4	D3809-1	SLIDING BLOCK
			1			D3811-041	SEAT TRACK ASSEMBLY
	1		1			D4575-1	BEAM
	1		1			D4575-3	DOUBLER
				1	1	D5162-041	SEAT STRUCTURE ASSEMBLY
			9			MS21042L3	NUT (OR MS21042-3)
	12					MS21059L3	NUTPLATE
	2					MS24693-S273	SCREW
			9			MS24694-S50	SCREW
	6					MS27039-1-10	SCREW
	6					NAS1149D0332J	WASHER (OR AN960JD10L)
			9			NAS1149D0363J	WASHER (OR AN960JD10)